

Date: Wednesday, 14/11/2007 11:51:08 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WINDOW FRAME
Job Number	: 35723	Part Number	: D35433
Estimate Number	: 13068	Drawing Number	: D3543 REV B
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 14/11/2007	S.O. No.	: N/A
Prsh Rev.	: NC	Type	: SMALL /MED FAB
First Issue	: N/A	Material	: N/A
Previous Run	: N/A	Due Date	: 23/11/2007
Written By		Qty:	5 Um: Each
Checked & Approved By			
Comment	: Est Rev:A New Issue 07-11-14 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3 .063 sheet IS.9636
		Comment: Qty.: 2.6606 sf(s)/Unit Total : 13.3030 sf(s) Material: 2024T3 sheet 0.063" thick. Batch <u>106223</u> HB07-11-14
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3543 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> HB07-11-14
		(6)
		2-Deburr if necessary HB 07-11-14
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB07-11-14
		(6)
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK J2-11-14 (6)
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 BL 07-11-15
		(6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 01/11/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 14/11/2007 11:51:08 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW FRAME

Job Number: 35723

Part Number: D35433

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		SO SO
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	
8.0	PACKAGING 1	PACKAGING RESOURCE #1
		SO
	Comment: PACKAGING RESOURCE #1 Identify with P/N and B/N using a permanent fine point marker, then Stock Location: 28	7-11-15 6X
9.0	QC21	FINAL INSPECTION/W/O RELEASE
		⑥ 7-11-16
	Comment: FINAL INSPECTION/W/O RELEASE	7-11-16

Job Completion



U 8/11/16

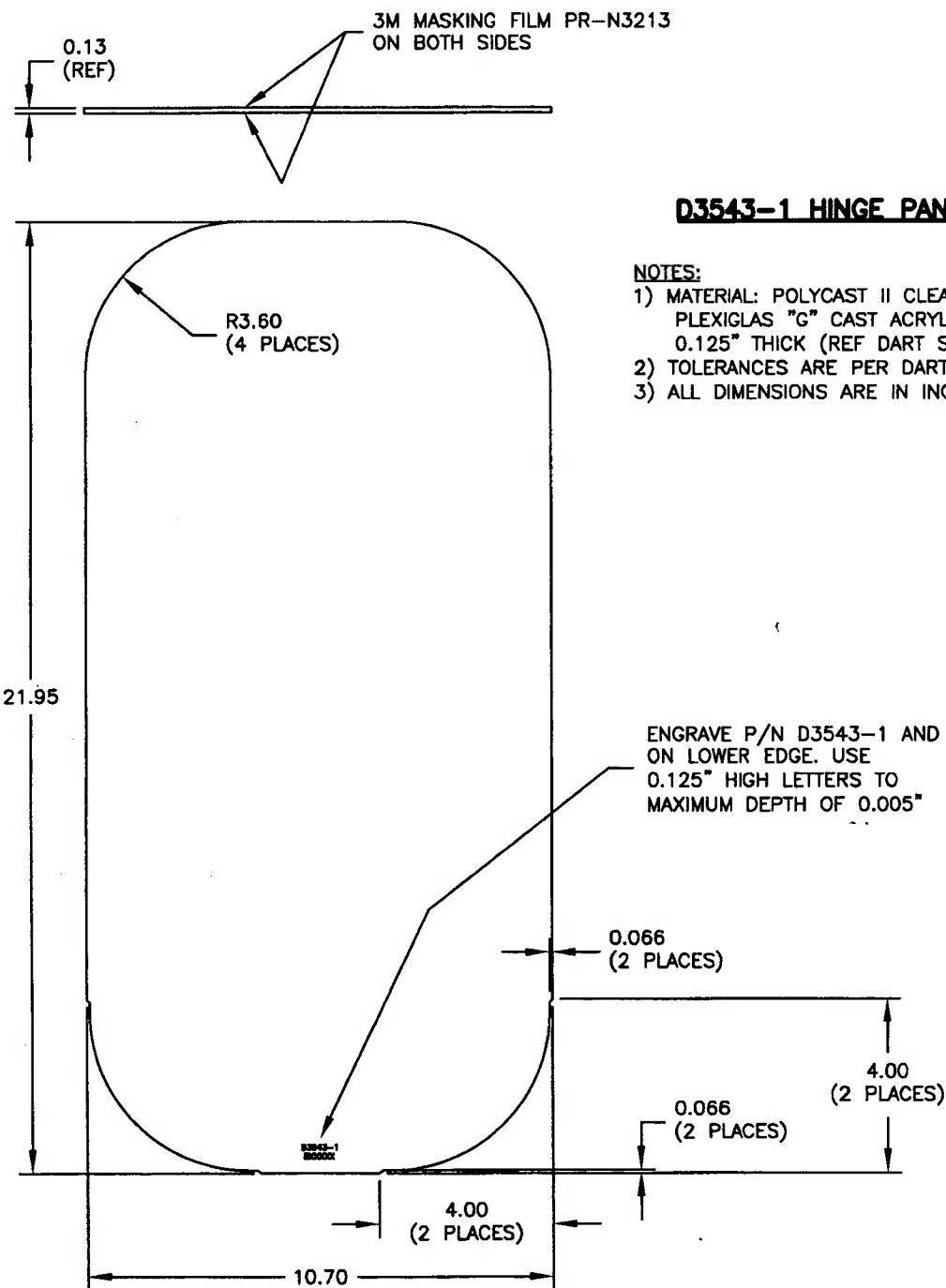
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**D3543-1 HINGE PANEL DOOR PUSH-OUT WINDOW**

NOTES:

- 1) MATERIAL: POLCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS "G" CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125" THICK (REF DART SPEC. M-ACRYLIC-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

RELEASED
NOV 12, 12
[Signature]

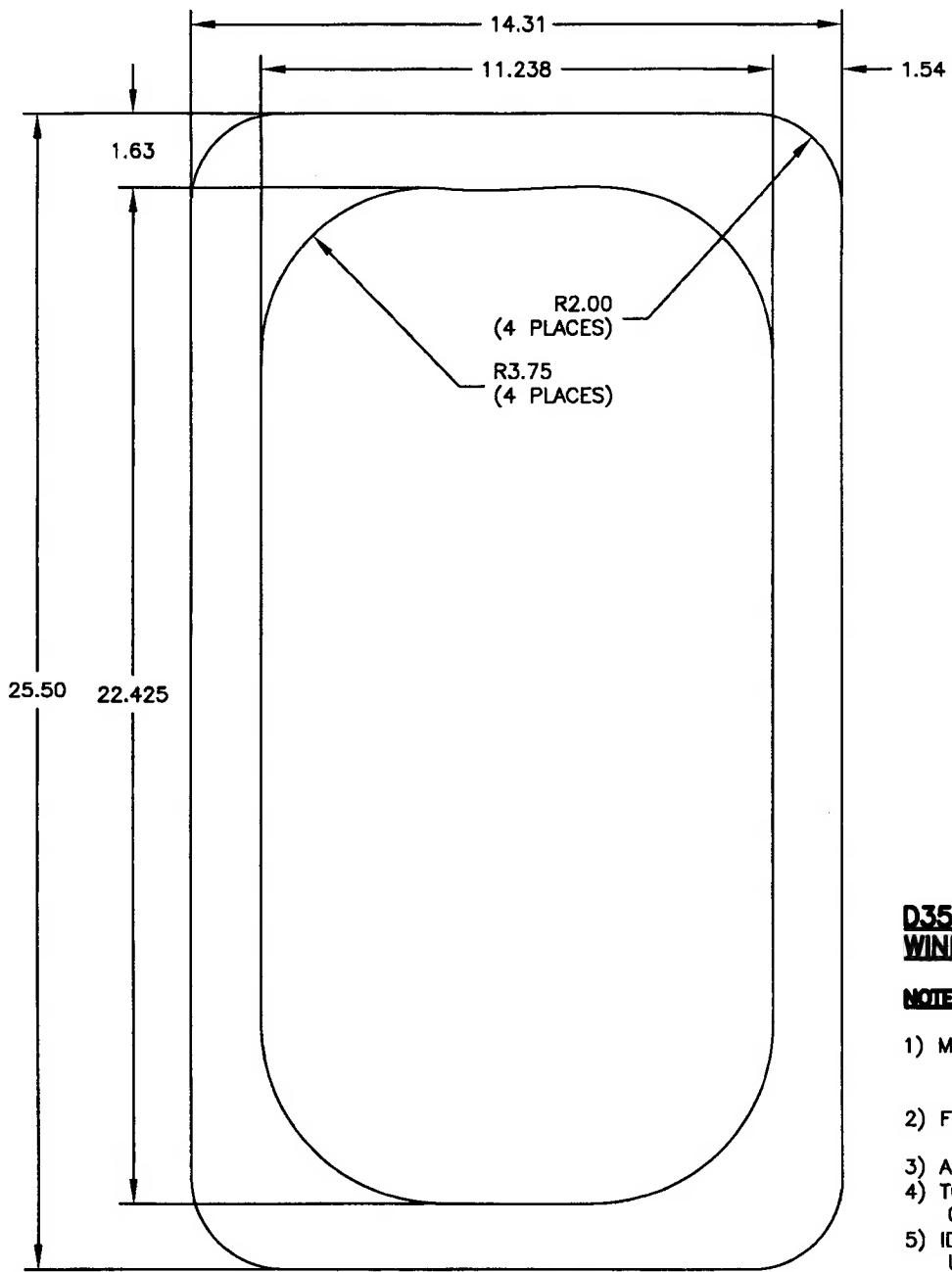
DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3543	REV. B	SHEET 1 OF 2
DATE 06.11.24		TITLE HINGE DOOR PUSH-OUT WINDOW	SCALE 1:4	
A	06.08.01	NEW ISSUE		
B	06.11.24	REMOVE D3568-1 PLACARD; D3543-041 ASS'Y NOT REQUIRED ANYMORE		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Copyright © 2006 by DART AEROSPACE LTD

D3543-3 HINGE DOOR PUSH-OUT
WINDOW FRAME

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK ALUMINUM SHEET
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) IDENTIFY WITH DART P/N D3543-3 & B/N USING FINE POINT PERMANENT MARKER

DESIGN <i>fb</i>	DRAWN BY <i>fb</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>SH</i>	DRAWING NO. D3543	REV. B	SHEET 2 OF 2
DATE 06.11.24	TITLE HINGE DOOR PUSH-OUT WINDOW	SCALE 1:4		

RELEASED
06.12.12

DART AEROSPACE LTD	Work Order:	35723
Description: WINDOW FRAME	Part Number:	D 3543-3
Inspection Dwg: D 3543-3 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	IB	Audited by:		Prototype Approval:	NA
Date:	07-11-14	Date:	07-11-14	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	